

Work Order ID 63663

Tuesday, November 09, 2010 8:27:56 AM



Page 1

Item ID:	D3915-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Rib					
Start Date:	11/9/2010	Start Qty: <u>2</u>		Cust Item ID:		
Required Date:	11/16/2010	Req'd Qty: 4.00		Customer:		
Reference:						

Approvals:	Process Plan: <u>MP</u>	Date: <u>10-11-9</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<u>Draw Nbr</u>	<u>Revision Nbr</u>								
D3915	C								
100		0.00							
Large Fab									
Large Fab	Memo	0.00							
	1- Cut tube as per dwg D4019								
	2- Drill hole as per dwg use DT9618								
	3- remove identification marks and deburr								
110	QC5- Inspect part completeness to step on W/O	0.00							
QC									
Quality Control	Memo	0.00							
120	Identify as per dwg & Stock Location: <u>B/C</u>	0.00							
Packaging									
Packaging	Memo	0.00							

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

SAO

~~10-11-09~~
10-11-09

Siolulro

4
2

72

Pl 10-11-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63663

Tuesday, November 09, 2010 8:27:56 AM

Page 2

Item ID: D3915-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Rib

Start Date: 11/9/2010 Start Qty: 4.00

Required Date: 11/16/2010 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10-11-18

mf
10-11-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Tuesday, November 09, 2010 8:27:56 AM

Work Order ID: 63663



Parent Item: D3915-1



Parent Item Name: Rib

Start Date: 11/9/2010

Required Date: 11/16/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as
per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg revC
DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6TS0.750W.06 2		Purchased	No			100	f	147.2282	8	33.68421			



SAD 10-10-09

6061-T6 SQ Tube .75 x .75 x .062W

Location	Loc Qty	Loc Code
MAT	69.55297	
114573	22.1055	
114640	47.44747	
MAT06	77.6752	
103069	38.0526	
104422	15.5263	
16441	4.07	
9671	20.0263	

3-16-8922

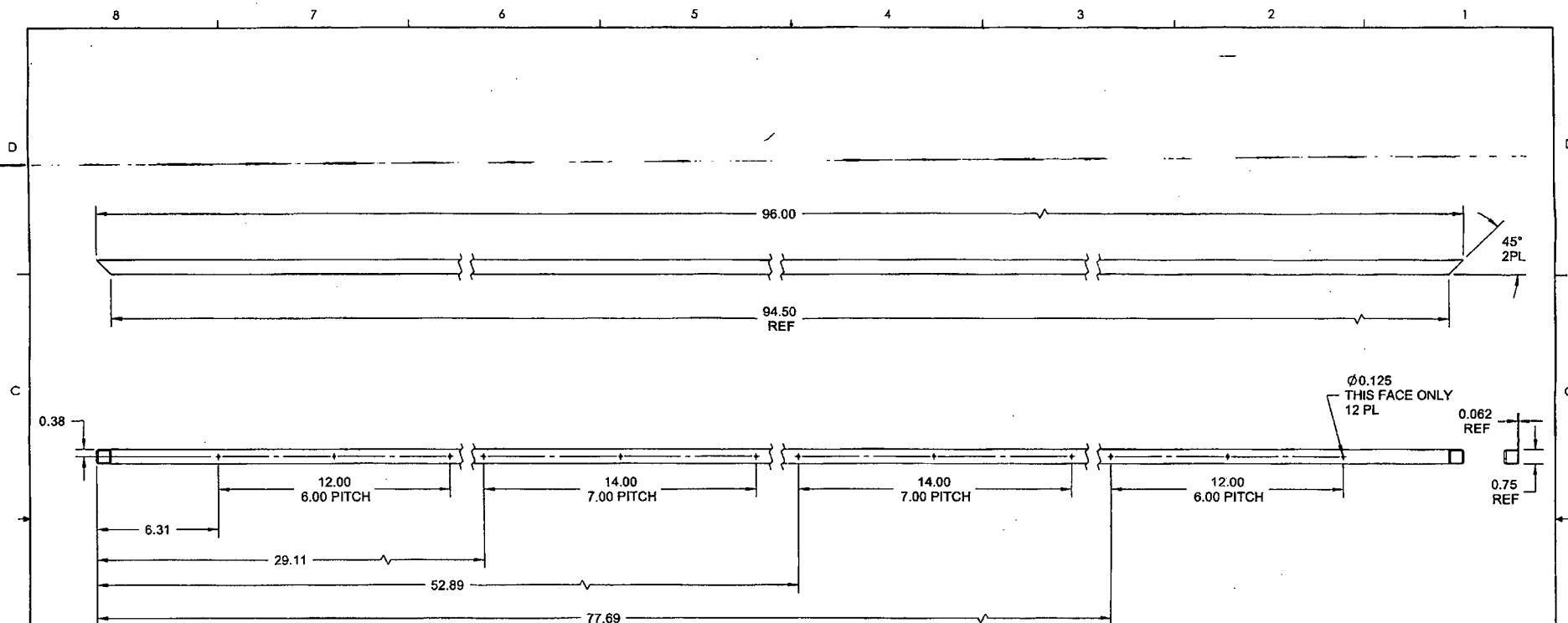
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3915-1 RIB

#63663

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6511/ T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6061T6TS0.750W.062
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.49 lbs

RELEASED
10.01.12

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	Sc	DRAWING NO. D3915	REV. C SHEET 4 OF 4
CHECKED	Sc	TITLE LIGHT LID ASSY-LONG BASKETNTS	SCALE
MFG. APPR.	Sc	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
APPROVED	Sc	DATE 10.08.05	
DE APPR.	Sc		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Receiving Report

Date: 10/5/10
 Supplier: TW Metal

Batch No: M114690
 Dart P/O: 11825

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☒ No ☐
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☒ No ☐ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection ☒ N/A ☐
 Work Order 1010512 N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 [Signature]

Production/Admin: 10/5/11
 Date
 Received/Costing
 Initial

Location



760 Constitution Drive
P.O. Box 644
Exton, PA 19341-0644

PAGE 1

* INVOICE *

REMIT TO:

TW METALS, INC
PO. BOX 933014
ATLANTA

GA 31193-3014

RECEIVED MAY 13 2010

SALES OFFICE 585-768-5600

FED ID: 25-0883470

SOLD TO:

DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY ON K6A 1K7
CANADA

SHIP TO:

DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY ON K6A 1K7
ONTARIO CANADA

YOUR ORDER NO.		YOUR REFERENCE NO.		DATE SHIPPED	DATE INVOICED	INVOICE NUMBER
P011825				05/05/10	05/05/10	80394474
SHIP	BAX 3-5 DAY	C	1203820	NET 30 DAYS		
QUANTITY		DESCRIPTION		UNIT PRICE	UNIT MEASURE	AMOUNT
1		D6061-T6 3/4 SQ X .065 WA RD CORNER		120.000	FT	
		ECCN:EAR99		10	EA	
		LENGTH: 12 FT ML				420.00

1244

1236

1/1

ORIGINAL

IF PAID WITHIN DISCOUNT
PERIOD DEDUCT

REVENUE	DISCOUNT	PROCESSING	FREIGHT	SALES TAX	TOTAL INVOICE
420.00	.00	.00	.00	.00	420.00
			.00	.00000	



PACKING SLIP

ORDER NO. 39394474

FROM: CHIC

PAGE 1

CUST NUMBER: 1203820

NET WT:

24.710

REQ DATE: 05/11/10 CONFIRMED

SHIP TO:

SHIP TO:

DART AEROSPACE LTD

DART AEROSPACE LTD

1000 BARKER ST

1210 BARKER ST

HAMPSHIRE ON

HAMPSHIRE ON

CANADA

CN K6A 1K7

ONTARIO CANADA

CN K6A 1K7

SALES PERSON:

SALES PERSON:

SHIPMENT:

CHICAGO

TERMS:

TERMS:

DATE:

BAY 3-5 DA.

DATE:

DATE:

DATE:

COLLECT

DATE:

DATE:

DATE:

RECEIVING PHONE

ITEM DESCRIPTION

WIDTH

LENGTH

DART 0001 0001 3/4 50 465 WA 40 CORNER

12 FT ML

OFF

120.000 FT

WT:

24.710 PC

10 SHP

120.000 FT

ECCL KAR99

PO 49225809 HT 000045750001

PC 10

SLB/CL 205020

MFG UNITED STATES

DATE:

DATE:

DATE:

DATE:

WIDTH

LENGTH

DATE:

DATE:

DATE:

DATE:

12.5000

DATE:

DATE:

DATE:

DATE:

DATE SHIPPED

DATE FILLED

THANK YOU FOR THIS ORDER

TERMS AND CONDITIONS APPLICABLE TO THE SALE OF THESE PRODUCTS ARE SET FORTH ON THE REVERSE SIDE FOR YOUR CAREFUL REVIEW.

KAISER ALUMINUM FABRICATED PRODUCTS

KAISER ALUMINUM
FABRICATED PRODUCTS, LLC
6573 W. WILLIS ROAD
CHANDLER, AZ 85226

CERTIFIED TEST REPORT
<http://Certs.KaiserAluminum.com>

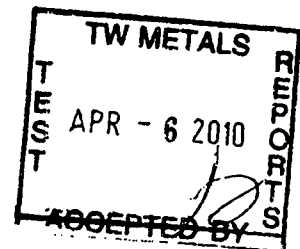
CUSTOMER PO NUMBER: M49225809-1		CUSTOMER PART NUMBER: 86913		PRODUCT DESCRIPTION: Seamless Tube/Pipe	
KAISER ORDER NUMBER: 205020	LINE ITEM: 001	SHIP DATE: 03/27/2010	KAISER LOT NUMBER: F00007573	ALLOY: 6061	TEMPER: T6
WEIGHT SHIPPED: 459.000 LB	QUANTITY: 198.000 PCS	B/L NUMBER: 204253	DIAM/DAF/THKNS: 	WIDTH: 	LENGTH: 12.000 FT
SHIP TO: TW METALS INC 235 WEST TUBEWAY DRIVE CAROL STREAM, IL 60188 USA			SOLD TO: TW METALS INC 760 CONSTITUTION DRIVE SUITE 204 EXTON, PA 19341 USA		

Actual Physical Properties

REFERENCE	DASH#	SAMPLE#	UTS (KSI)	YTS (KSI)	ELONG%	HARDNESS	CONTRACTS	BEND
F00007573	0001	1	48.7	46.5	15.9	N/A	N/A	N/A

Chemical Composition (wt%), Aluminum Remainder

LIMITS	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Zr	Ea	Tot
Maximum	0.80	0.70	0.40	0.15	1.20	0.35	0.25	0.15	NA	NA	NA	0.05	0.15
Minimum	0.40	0.00	0.15	0.00	0.80	0.04	0.00	0.00	NA	NA	NA	0.00	0.00
D67811	.53	.29	.24	.06	.96	.06	.06	.02	.00	.00	.00	.01	.02
D67767	.62	.33	.24	.05	.96	.09	.07	.03	.00	.00	.00	.01	.02



CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC ('Kaiser') hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms & conditions of sale. Test reports are on file subject to examination.

Chris Garcia, Quality System Engineer

Christopher J. Garcia

Plant Serial: 00006613

Kaiser Order Number: 205020

Line Item: 001

DART
aerospaceDart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053**PURCHASE ORDER**Purchase Order ID **PO11825**

Purchase Order Date 5/04/10

PO Print Date 5/04/10

Page Number . of 1

Order From :

TW METALS
PO BOX 933014
ALTANTA, GA 31193-3014
US

VU-TWM001

Contact Name

Vendor Phone 585 768 5600

Vendor Fax 585 768 5601

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms

Net 30

Currency

USD

FOB

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA**FAXED**
67053

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M6061T6TS0.750W.062	6061-T6 SQ Tube .75 x .75 x .062W	5/11/10 Yes	✓ 120.00 f		\$3.5000	\$420.00

Special Inst: MATERIAL: 6061-T6 OR 6061-T62
TUBING PER
WW-T-700/6 OR AMS4080 OR AMS 4082
OR
QQ-A-200/8 OR QQ-A-225/8
MATIAL: 6061-T6 SQUARE TUBING
*.750" X .750" X .065" WALL *

PO Total:

\$420.00

**MATERIAL CERTIFICATION
REQ'D UPON DELIVERY**

PO Instructions:

PLEASE SHIP: BAX GLOBAL ACCT:152700192 *

Change Nbr: 1

Change Date: 5/04/10

No substitution or deviation without
consent.Certificate of Conformity or Material
Certification required when applicable